

Friday, 26/09/2008 3:04:13 PM
Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	350 SKIDTUBE ASSEMBLY RH
Job Number :	42313		
Estimate Number :	10268		
P.O. Number :		Part Number :	D350636014
This Issue :	26/09/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2750 REV F
First Issue :	1/1	Project Number :	N/A
Previous Run :	42312	Drawing Revision :	F
	Type :	Material :	
	SKIDTUBES	Due Date :	12/10/2008
Written By :		Qty:	1
Checked & Approved By :	JLD 08.9.26	Um:	Each
Comment :	: Est Rev:H 02.09.25 Rearranged procedure steps KJ : Est Rev:I 05.12.08 Rearranged procedure steps EC : Est Rev:J 06.03.30 Per rev. D EC : Est Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM : Verified By:EC : Est Rev:M 08-09-23 revF as per dwg DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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JLD 08.10.01



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-014 CHG 004

2.0	D26003BENT	Extrusion Bent
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2600-3-Bent	Extrusion (Bent)	B39242

3.0	D2744	Cap
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch:

B39242

4.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 3 (D2750-1 details).Drill using drill Jig DT8150 & DT8864 .

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 42313

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8864 and cut as per dwg D2750.

4-Drill pilot holes for Detail G using DT8329.

5-Open up holes for Detail B to 0.375 (2 holes per side) and blade fitting location holes to 0.500" (total of 5 holes per side) as per dwg D2750. Open holes for ground handling and detail E to 0.500" (8 holes per side)

6-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 and open to 0.297" ***Make sure that wearplate holes are on bottom of tube*** Open 4 aft wearplate holes to 0.250". Open remaining wearplate holes to 0.297".

7-Open up holes of Detail A to 0.297" (total of 2 holes per side)

9-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004
A/R Aluminum Rod *m 109213 SE 08/10/02*

10-Grind welds flush as per Dwg D2750 *SE 08-10-02*

11-Countersink Detail A as per dwg D2750.

M 2102

5.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

08/10/03 (F)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/10/03 (F)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JD 8-10-3

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/10/03 (F)

9.0

D2739

350 I Beam



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Web

Batch:

B 42419

JD 8-10-6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Process Sheet

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Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 42313

Part Number: D350636014

Job Number:



Seq. #:	Machine Or Operation:	Description :
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10.0	D34901	Cross Bolt Spacer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Crossbolt spacer

Batch: *342185*

BE 08/10/07

11.0	D34905	Cross Bolt Spacer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Crossbolt spacer

Batch: *322597*

BE 08/10/07

12.0	D2743	Crossbolt Spacer
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Crossbolt Spacer

Batch: *328755*

BE 08/10/07

13.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Open up holes section T-T 0.500" (4 per side) as per dwg D2750

2-Open holes section V-V 0.3125" (4 per side)

3-Open up holes of Detail E and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

4-Chamfer holes of Detail V, Detail C, hole size "W" and "X" per dwg D2750 (welding instructions on sheet 5)

5-Deburr and blow out all chips from inside of tube. Prepare tube for welding, remove alodine as required.

6-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291

batch: *m 169338*
exp. date: *8-4-01*

7- Weld spacers D3490-1, D3490-5 and D2743 as per dwg D2750 & QSI004

(welding instructions on sheet 5)

A/R

Aluminum Rod

batch: *m 109213* *BE 08/10/07*

8-Grind welds flush as per Dwg D2750

9-Spot face ground handling holes section P-P (total of 4 places per side) as per dwg D2750

JP 8-10-6

RT 081007

W/O:		WORK ORDER CHANGES					
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Job Number: 42313

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

10-Deburr holes

25 08-10-07

14.0 QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

8 08/10/08 (X)

15.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/10/08 (X)

16.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

M-L 08/10/09

17.0 POWDER COATING

POWDER COATING



M 109152



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:40
320°F
4:10

M-L 08/10/09

18.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect for foreign object per QSI 024

08.10.14

(X)

19.0 ALS41032225

Insert



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Insert

Batch: M1100621

ell

20.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts as per dwg D2750

ell 08.10.14

(X)

W/O:		WORK ORDER CHANGES					
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Job Number: 42313

Part Number: D350636014

Job Number:



Seq. #:	Machine Or Operation:	Description :
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21.0	D2745	Bushing
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bushing

Batch: B41114

Handwritten signature

22.0	D37911	Wearplate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearplate

Batch: B42418

Handwritten signature

23.0	D37931	Wearshoe
------	--------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearshoe

Batch: B40551

Handwritten signature

24.0	D37933	Wearshoe
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearshoe

Batch: B42247

Handwritten signature

25.0	D37941	Gasket
------	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

Batch: B40553

Handwritten signature

26.0	D37943	Gasket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

Batch: B39713

Handwritten signature

27.0	D353525	Wearshoe
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B41633

Handwritten signature

08 10 - 14

Handwritten circled X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 42313

Part Number: D350636014

Job Number:



Seq. #:	Machine Or Operation:	Description :
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28.0	D353625	Gasket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B42234 JK

29.0	D35371	Wearpad
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

WEARPAD

Batch: B41082 JH

30.0	D36311	Washer
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

Batch: B41141 JH

31.0	D3488042	Blade Fitting Assembly, RH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade Fitting, RH

Batch: B36235 JH

32.0	D3492041	Plug Assembly
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: B42182 JH

33.0	D3492045	Plug Assembly
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: B33435 JH

34.0	AN3C5A	Bolt
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Comment: Qty.: 34.0000 Each(s)/Unit Total : 34.0000 Each(s)

Bolt

Batch: M108928 JH

08-10-14

XC

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 42313

Part Number: D350636014

Job Number:



Seq. #:	Machine Or Operation:	Description :
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35.0	AN3C6A	BOLT
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch: M1108880

JB

36.0	AN6C44A	BOLT
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

BOLT

Batch: M1109091

JB

37.0	AN8C35A	BOLT
------	---------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

BOLT

Batch: M1106896

JB

38.0	AN960C10L	washer
------	-----------	--------



Comment: Qty.: 38.0000 Each(s)/Unit Total: 38.0000 Each(s)

washer

Batch: M1109282

JB

39.0	AN960C816L	WASHER
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WASHER

Batch: M1108928

JB

40.0	MS210436	NUT
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

NUT

Batch: M1109249

JB

41.0	MS21083C8	NUT
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

NUT

Batch: M1109485

JB

08 10. 10 27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 42313

Part Number: D350636014

Job Number:



Seq. #: Machine Or Operation: Description :

42.0 NAS1515H3L WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

WASHER

Batch: M 108 964

el

43.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Assemble tube hardware as per dwg D2750 sikaflex batch: M 109 338 08/11

2-Inspect For Foreign Objects

3-Spray inside of tube with "LPS-3" batch: M 107 912

4-Install blade fitting D3488-041, wearshoe

SIKA FLEX 241

BATCH: M 109 338

EXP DATE: 08/11

5-Coat all exposed fasteners with "LPS Procyon" batch: M 104 251

el 08.10.15 (40)

44.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

509/10/17 (40)

45.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

46.0 D2741 Blade, 350 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade

Batch: 96 729

el 9/11/17 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 42313

Part Number: D350636014

Job Number:



Seq. #: Machine Or Operation: Description :

47.0 AN960C816L WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M109632

W

48.0 MS21083C8 NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: 109545

W

49.0 AN8C21A BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M109092

W

50.0 NAS1515H8L WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: M128969

W

51.0 D34931 Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: 40829

Rev G *10/17* *(1)*

52.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

08/10/17 *(2)*

53.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-014

Rev G *10/17* *1C*

B42313

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

54.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/2008

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-10-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

NO. 175

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 41860
Part number: D350 436011
Description: 350 skid
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Det. Dineal Date of Test Coupon 08-09-26
Welder Barclay Elliott Date of Test Coupon 08-09-26

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

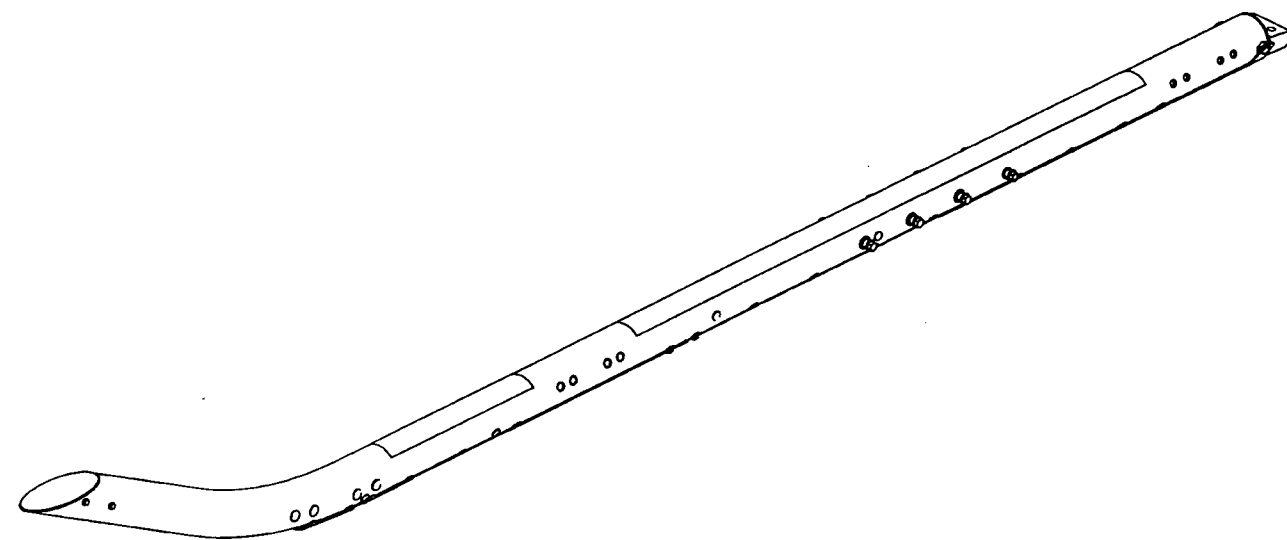
GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

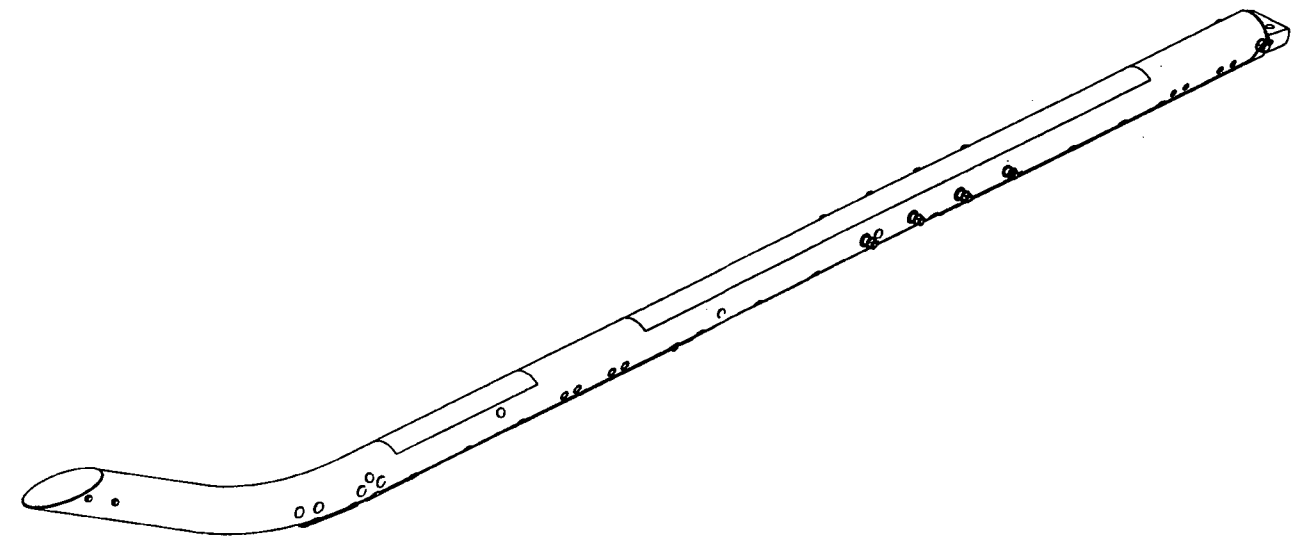
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F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL), WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	PA	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
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MFG. APPR.	AK	D2750	SHEET 1 OF 11
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D2750-041 350 SKIDTUBE ASSEMBLY, LH

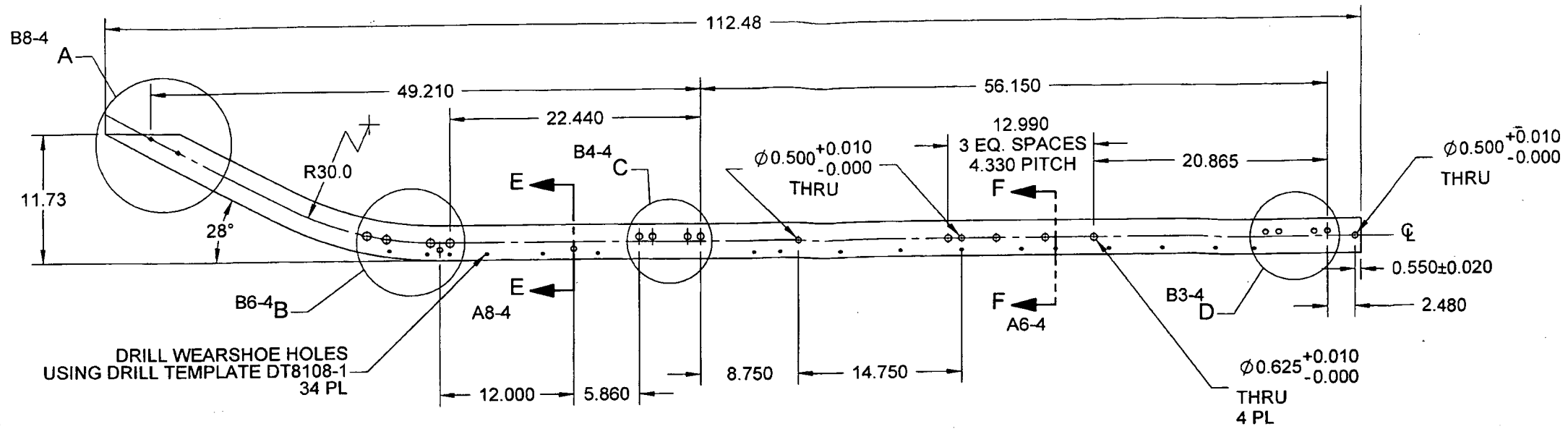


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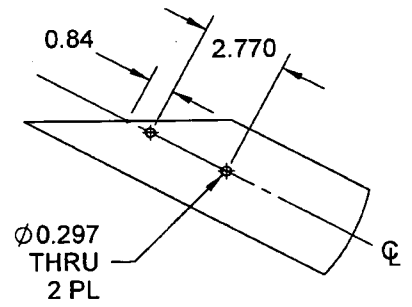
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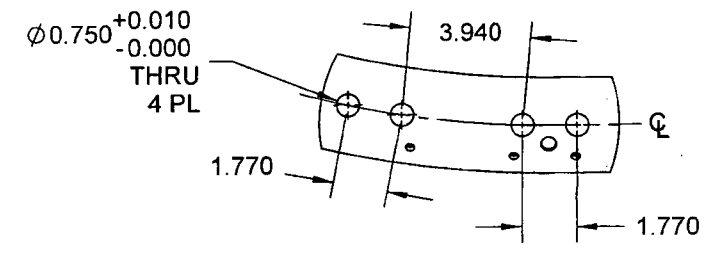
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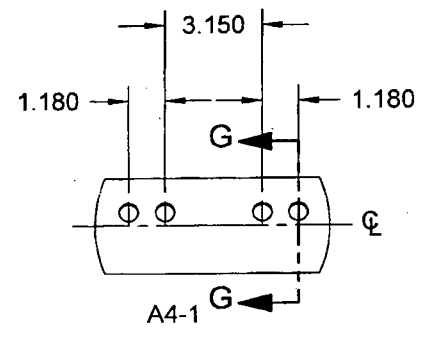
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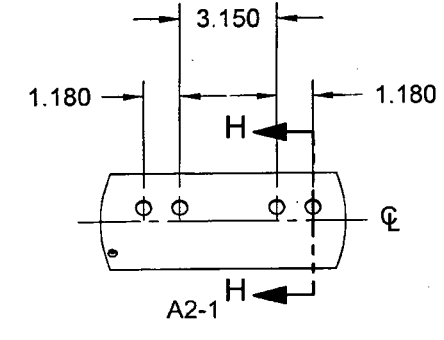
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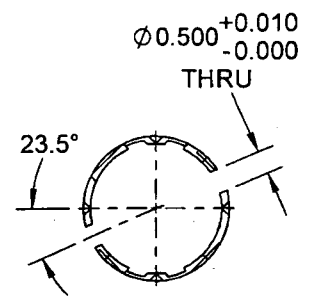
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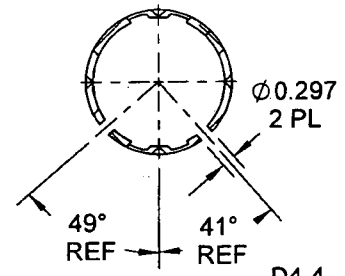
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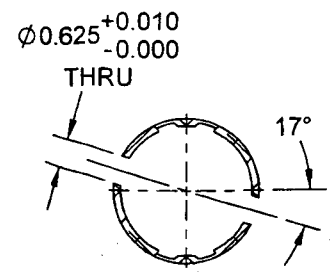
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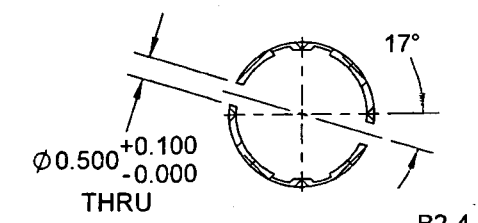
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL

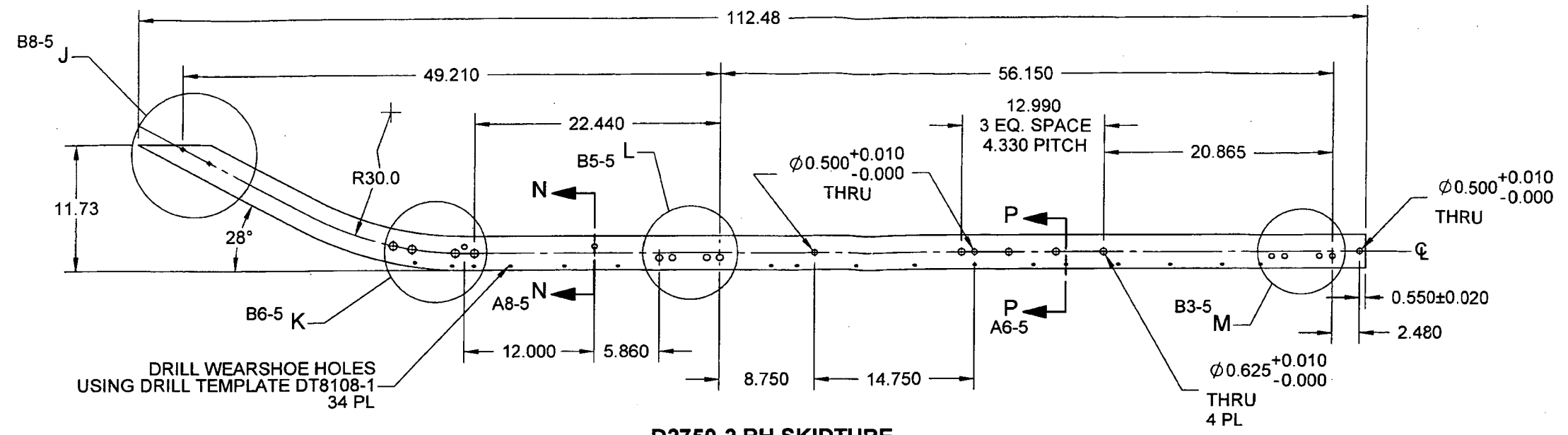


SECTION H-H
SCALE 3X, 4 PL

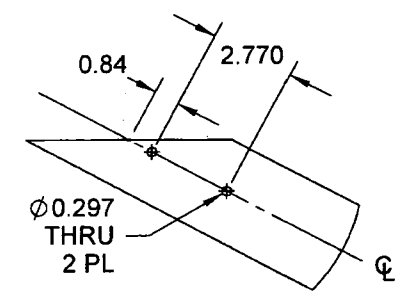
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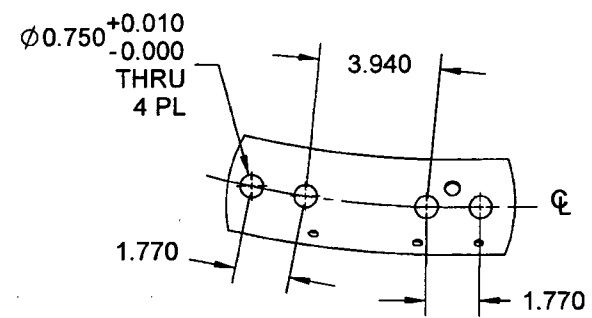
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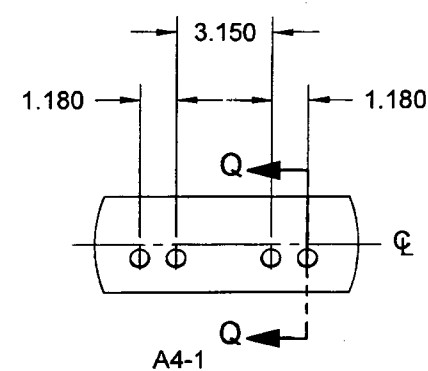
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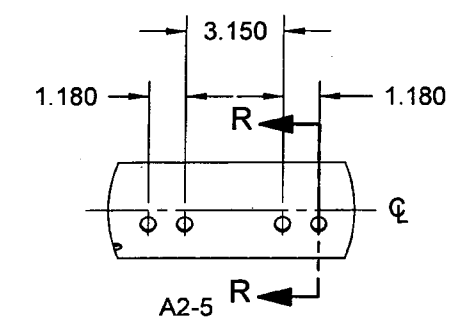
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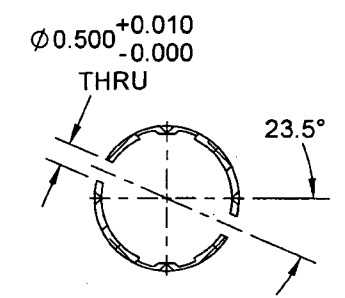
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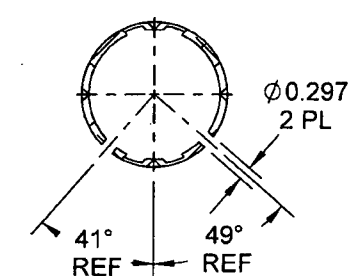
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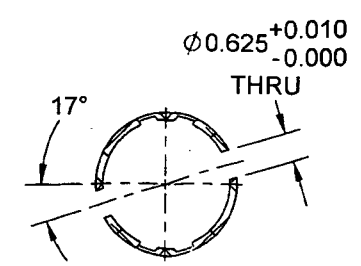
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SCALE 2X



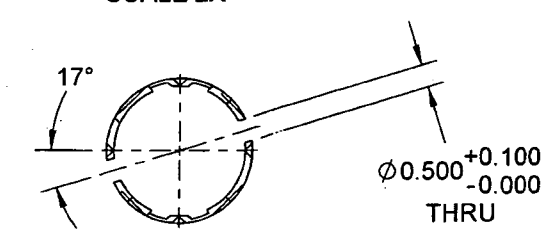
SECTION N-N
C6-5
SCALE 3X, 2 PL



SECTION P-P
C4-5
SCALE 3X, 17 PL



SECTION Q-Q
B5-5
SCALE 3X, 4 PL



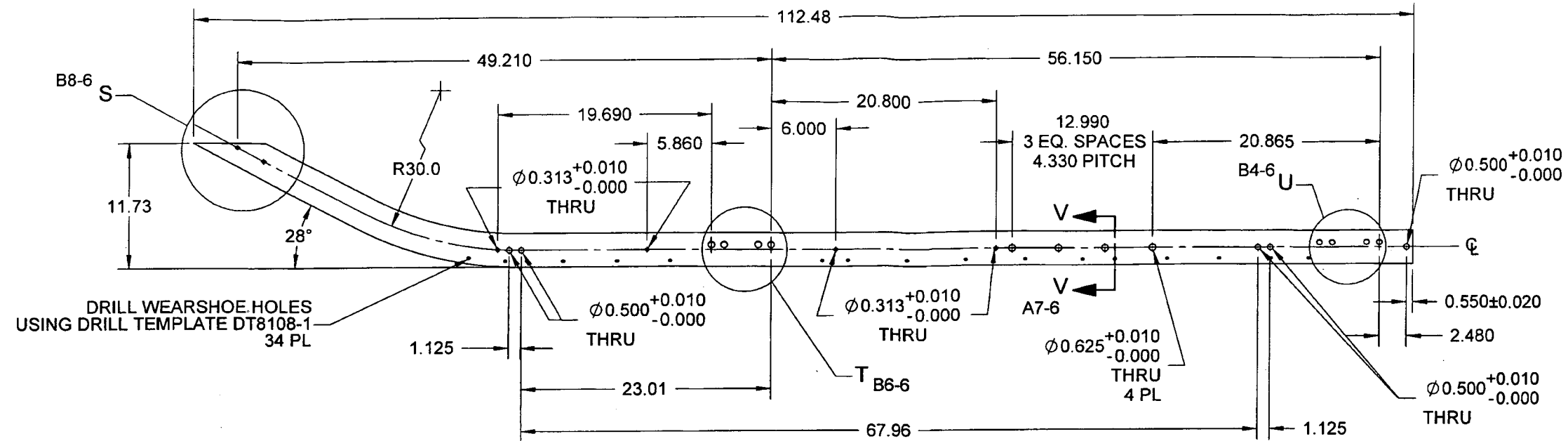
SECTION R-R
B3-5
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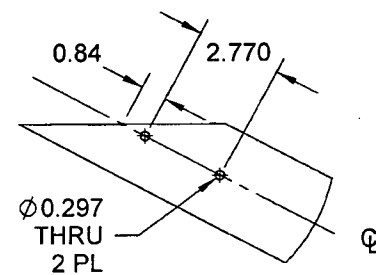
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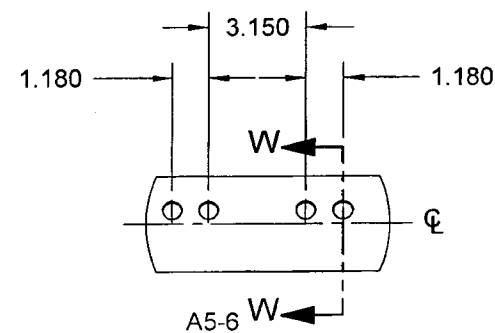
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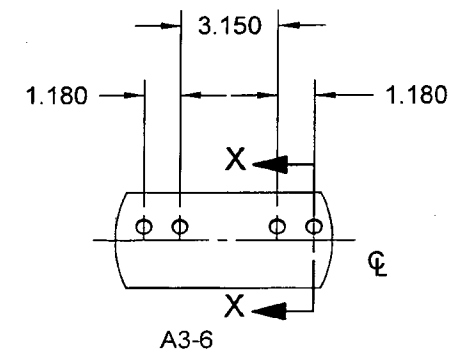
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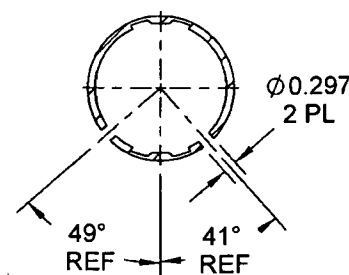
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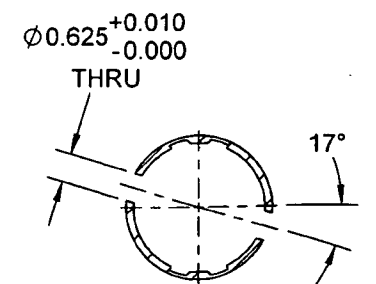
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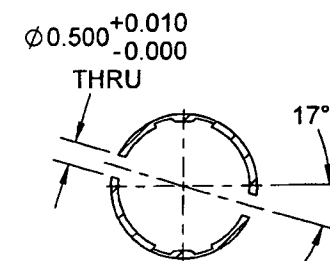
DETAIL U
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SECTION V-V
SCALE 3X, 17 PL



SECTION W-W
SCALE 3X, 4 PL

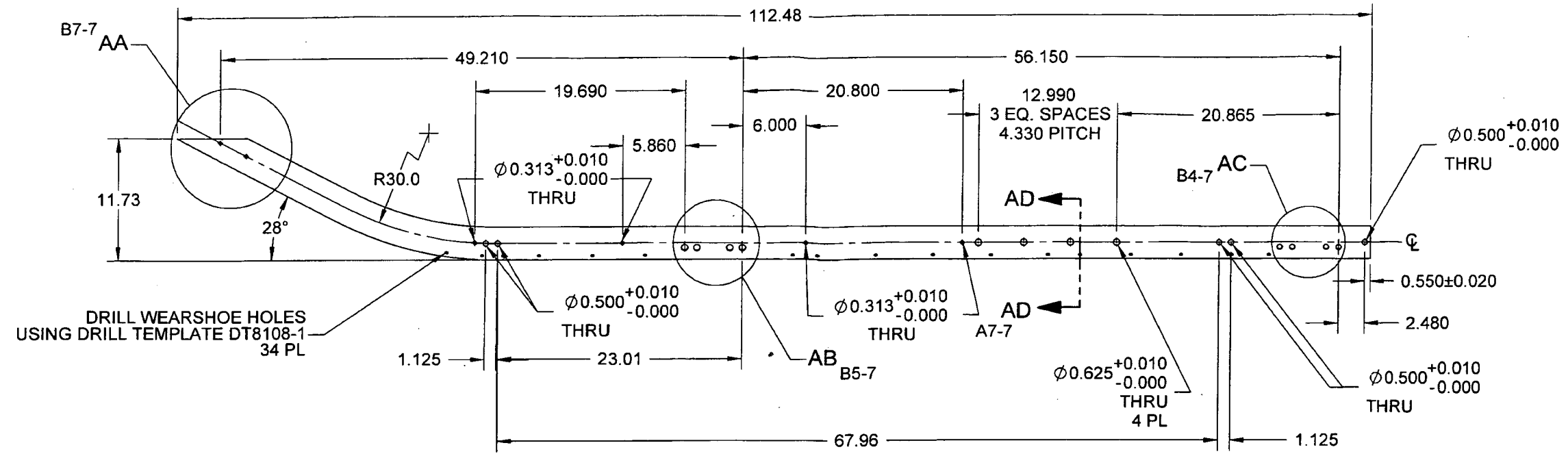


SECTION X-X
SCALE 3X, 4 PL

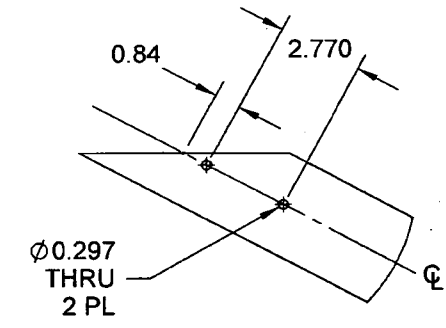
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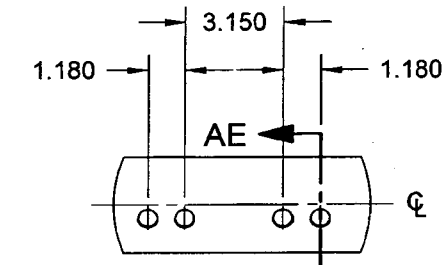
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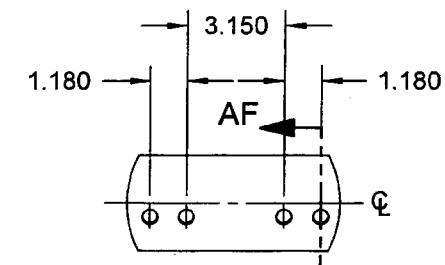
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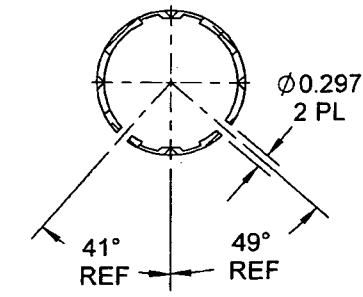
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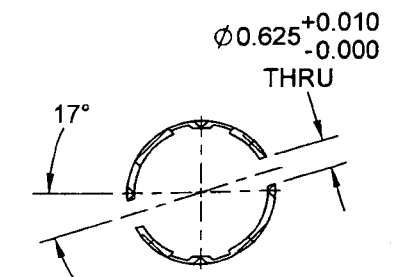
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C4-7
A5-7 AE



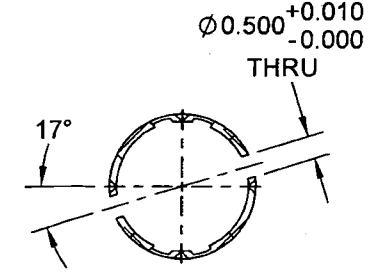
DETAIL AC
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D3-7
A3-7 AF



SECTION AD-AD
SCALE 3X, 17 PL
D3-7



SECTION AE-AE
SCALE 3X, 4 PL
B6-7

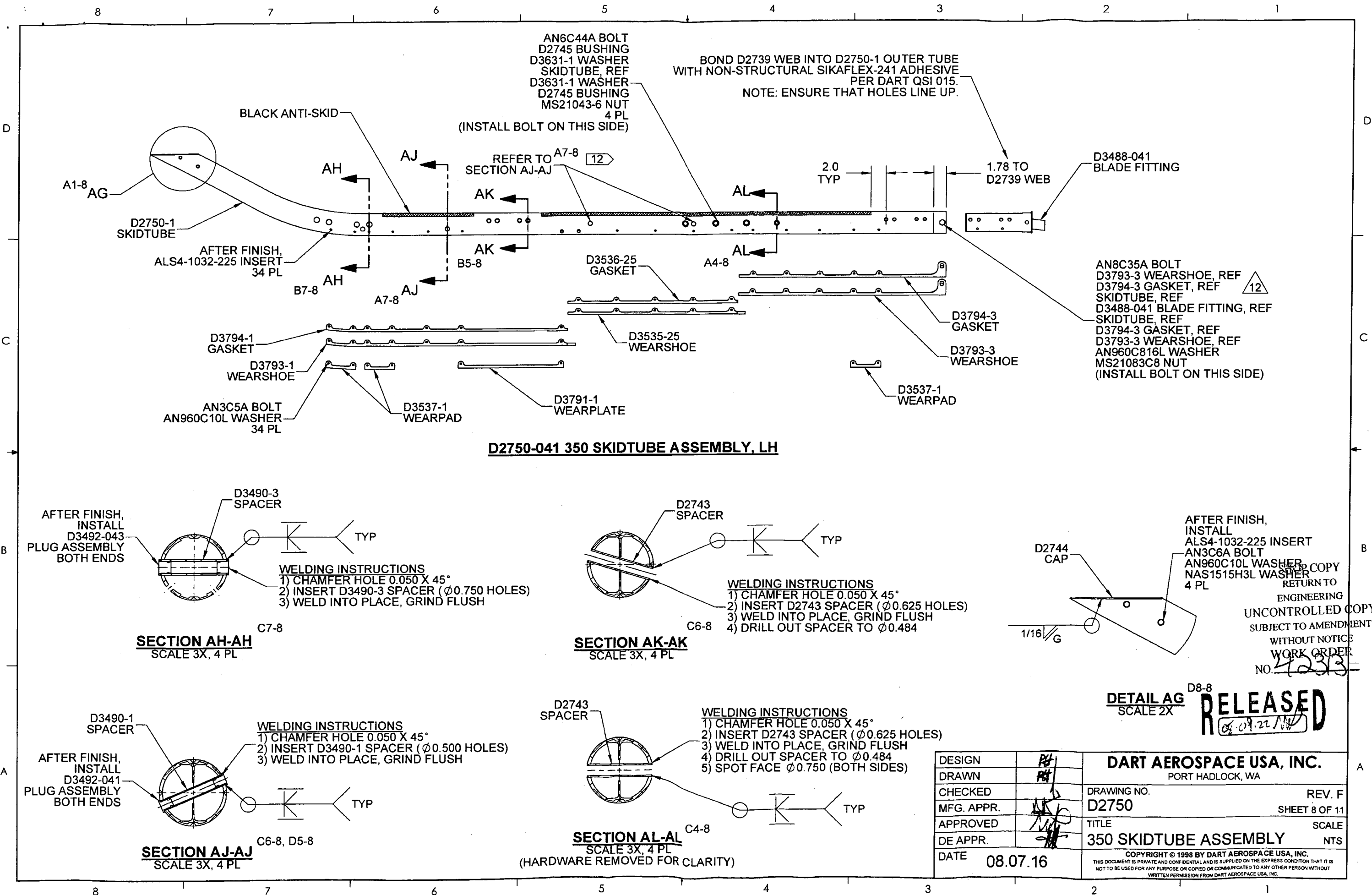


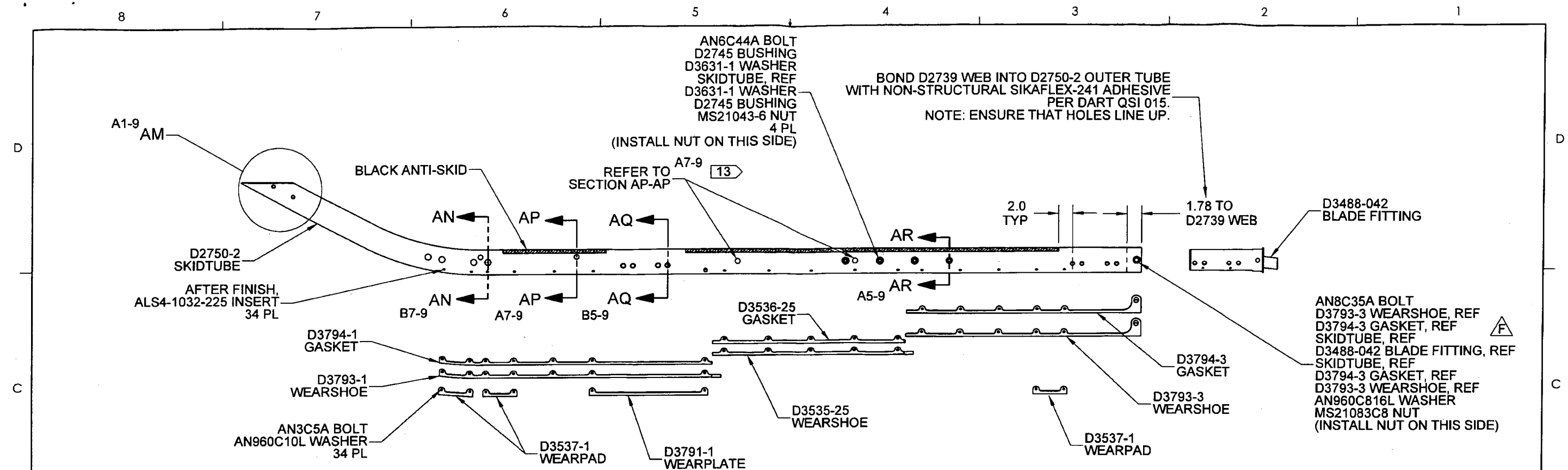
SECTION AF-AF
SCALE 3X, 4 PL
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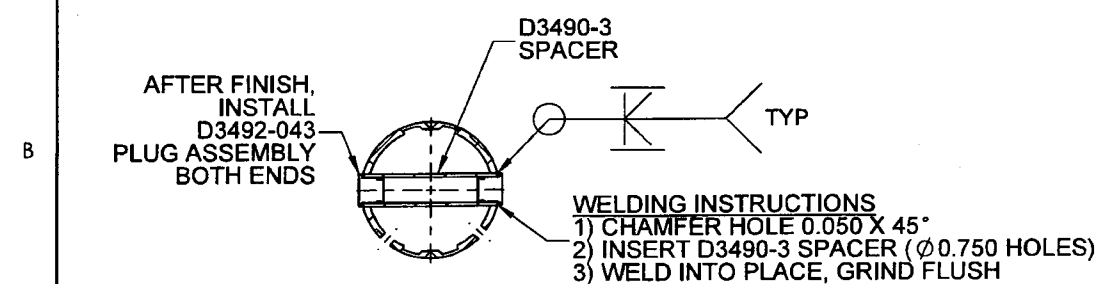
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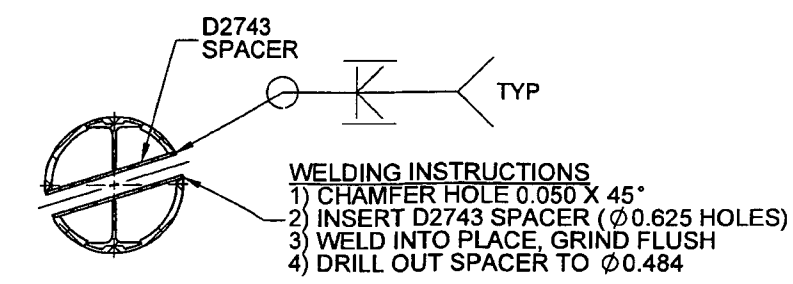




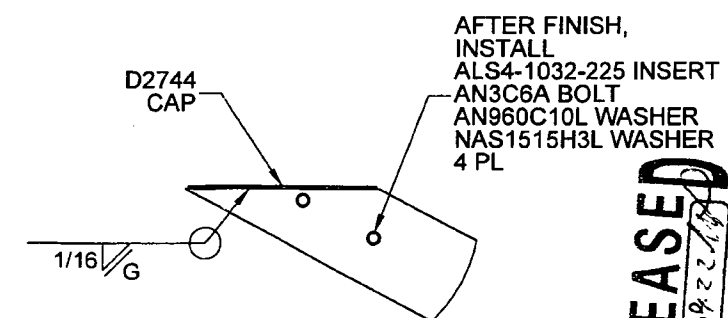
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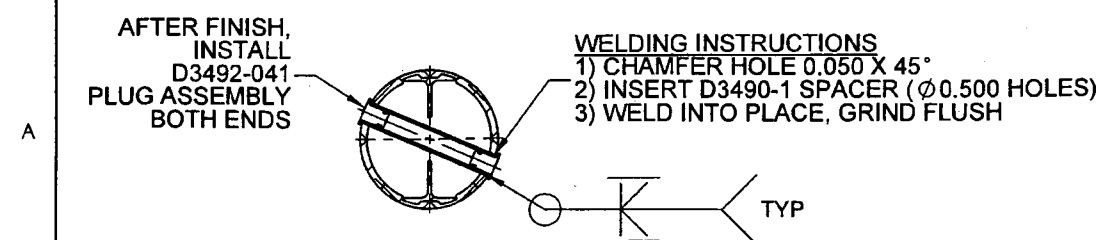
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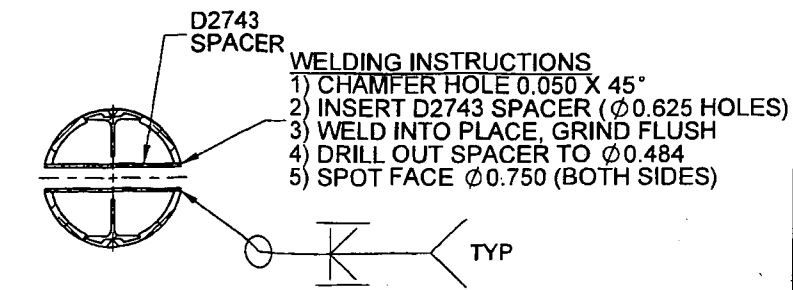
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


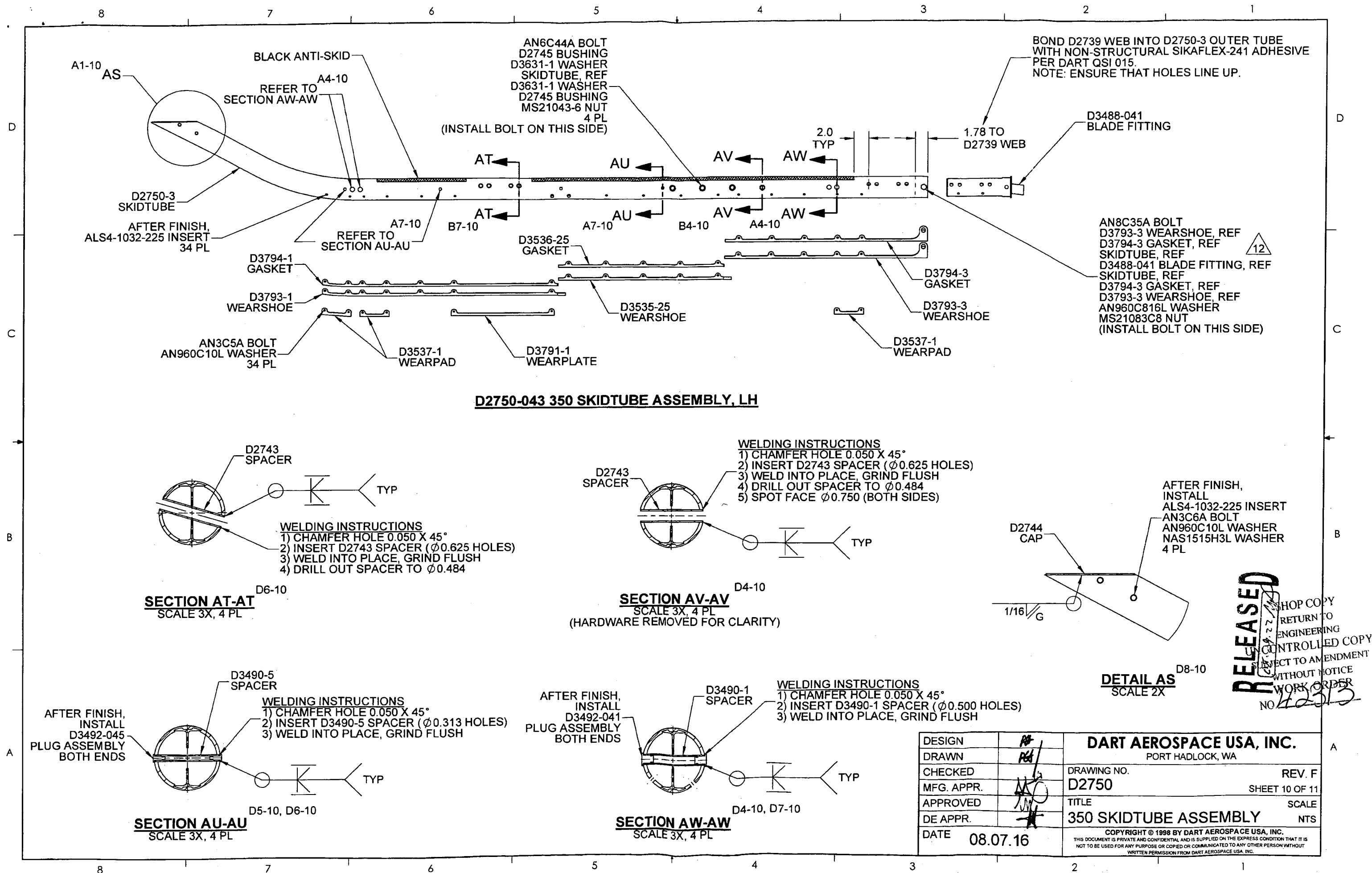
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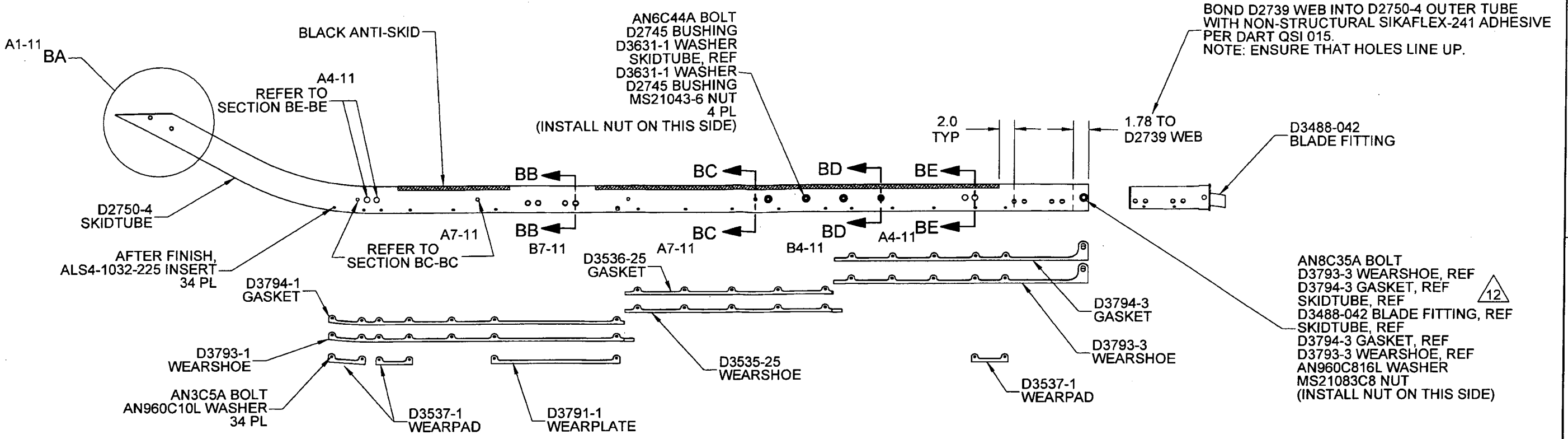
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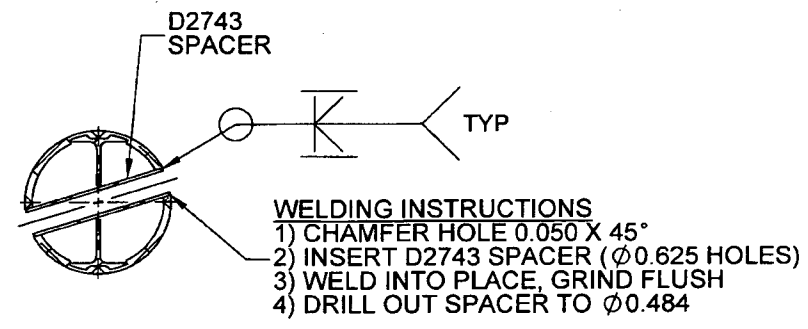
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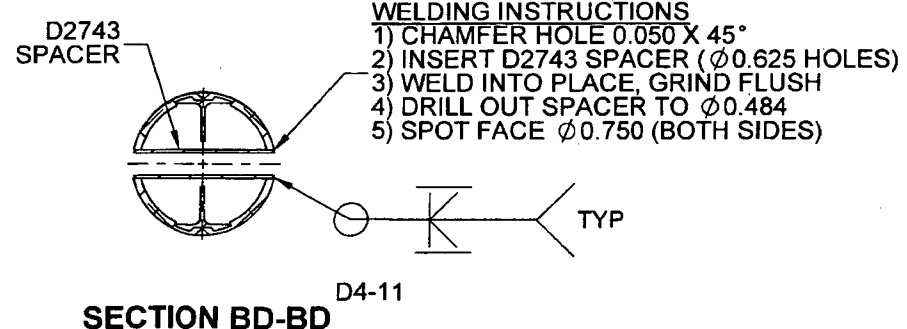
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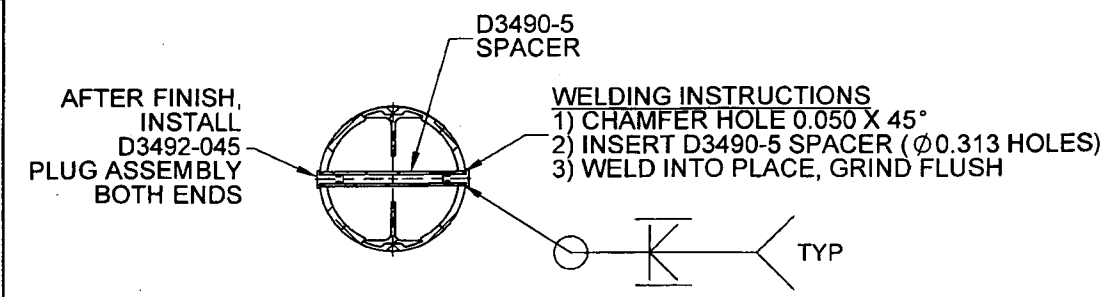
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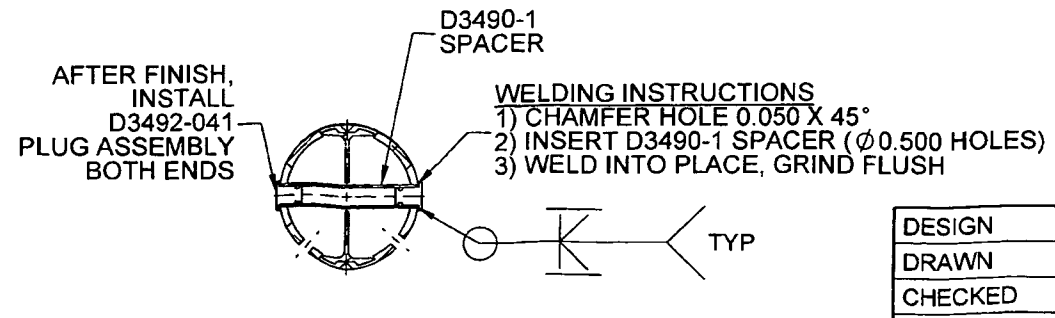
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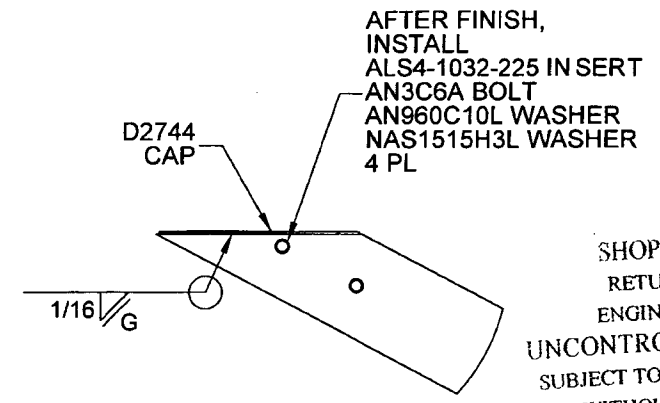
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SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



SECTION BC-BC
SCALE 3X, 4 PL



SECTION BE-BE
SCALE 3X, 4 PL



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8 7 6 5 4 3 2 1